

FORM PTO-1390 (REV. 11-2000)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE	ATTORNEY'S DOCKET NUMBER MPD314
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371			10/018818
INTERNATIONAL APPLICATION NO. PCT/GB00/02448	INTERNATIONAL FILING DATE 22 June 2000	PRIORITY DATE CLAIMED 24 June 1999	
TITLE OF INVENTION STRUCTURED SURFACTANT SYSTEMS			
APPLICANT(S) FOR DO/EO/US HATCHMAN, Kevan			
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:			
<p>1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371.</p> <p>2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371.</p> <p>3. <input type="checkbox"/> This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (21) indicated below.</p> <p>4. <input checked="" type="checkbox"/> The US has been elected by the expiration of 19 months from the priority date (Article 31).</p> <p>5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2))</p> <p>a. <input type="checkbox"/> is attached hereto (required only if not communicated by the International Bureau).</p> <p>b. <input type="checkbox"/> has been communicated by the International Bureau.</p> <p>c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US).</p> <p>6. <input type="checkbox"/> An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).</p> <p>a. <input type="checkbox"/> is attached hereto.</p> <p>b. <input type="checkbox"/> has been previously submitted under 35 U.S.C. 154(d)(4).</p> <p>7. <input type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))</p> <p>a. <input type="checkbox"/> are attached hereto (required only if not communicated by the International Bureau).</p> <p>b. <input type="checkbox"/> have been communicated by the International Bureau.</p> <p>c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired.</p> <p>d. <input type="checkbox"/> have not been made and will not be made.</p> <p>8. <input type="checkbox"/> An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).</p> <p>9. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).</p> <p>10. <input type="checkbox"/> An English language translation of the annexes of the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).</p> <p>Items 11 to 20 below concern document(s) or information included:</p> <p>11. <input type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98.</p> <p>12. <input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.</p> <p>13. <input checked="" type="checkbox"/> A FIRST preliminary amendment.</p> <p>14. <input type="checkbox"/> A SECOND or SUBSEQUENT preliminary amendment.</p> <p>15. <input type="checkbox"/> A substitute specification.</p> <p>16. <input type="checkbox"/> A change of power of attorney and/or address letter.</p> <p>17. <input type="checkbox"/> A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825.</p> <p>18. <input type="checkbox"/> A second copy of the published international application under 35 U.S.C. 154(d)(4).</p> <p>19. <input type="checkbox"/> A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).</p> <p>20. <input type="checkbox"/> Other items or information:</p>			
<p>CERTIFICATE OF MAILING BY EXPRESS MAIL</p> <p>Express Mail Label No. EL151304882US</p>			

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I hereby certify that the application/correspondence attached hereto is being deposited with the U.S. Postal Service "Express Mail Post Office to Addressee" Service under 37 C.F.R. 1.10 on the date indicated below and is addressed to Commissioner for Patents, Washington, D.C.

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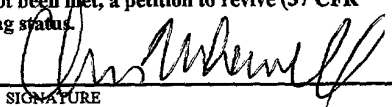
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Date of Deposit

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Annex US.II, page 2

PCT Applicant's Guide - Volume II - National Chapter - US

US APPLICATION NO. (37 CFR 1.53) 10/018818		INTERNATIONAL APPLICATION NO.		ATTORNEY'S DOCKET NUMBER MPD314	
21. <input checked="" type="checkbox"/> The following fees are submitted: BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)): Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO. \$1000.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO \$860.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$710.00 International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$690.00 International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) \$100.00 ENTER APPROPRIATE BASIC FEE AMOUNT =				CALCULATIONS PTO USE ONLY <div style="border: 1px solid black; padding: 2px;">\$ 890.00</div>	
Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				<div style="border: 1px solid black; padding: 2px;">\$</div>	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	\$	
Total claims	- 20 =		x \$18.00	\$	
Independent claims	- 3 =		x \$80.00	\$	
MULTIPLE DEPENDENT CLAIM(S) (if applicable)			+ \$270.00	\$	
TOTAL OF ABOVE CALCULATIONS =				\$ 890.00	
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27. The fees indicated above are reduced by 1/2.				+ \$	
SUBTOTAL =				\$ 890.00	
Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f)).				\$	
TOTAL NATIONAL FEE =				\$	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property +				\$	
TOTAL FEES ENCLOSED =				\$	
				Amount to be refunded:	\$
				charged:	\$
a. <input type="checkbox"/> A check in the amount of \$ _____ to cover the above fees is enclosed. b. <input checked="" type="checkbox"/> Please charge my Deposit Account No. <u>08-3442</u> in the amount of \$ <u>890.00</u> to cover the above fees. A duplicate copy of this sheet is enclosed. c. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. <u>08-3442</u> . A duplicate copy of this sheet is enclosed. d. <input type="checkbox"/> Fees are to be charged to a credit card. WARNING: Information on this form may become public. Credit card information should not be included on this form. Provide credit card information and authorization on PTO-2038.					
NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137 (a) or (b)) must be filed and granted to restore the application to pending status.					
SEND ALL CORRESPONDENCE TO: Mr. Russ Stolle Huntsman Corporation Legal Department P. O. Box 15730 Austin, TX 78761					
SIGNATURE  Christopher J. Whewell				NAME 37,469 REGISTRATION NUMBER	

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(1 January 2001)

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicants: Hatchman, et al.

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Docket # MPD314

Serial No. unk.(entry into National Stage in US
of PCT/GB00/02448

Filed: concurrently herewith

For: "STRUCTURED SURFACTANT
SYSTEMS"

December 18, 2001

Commissioner for Patents
Washington, D.C. 20231

Preliminary Amendment

Sir:

Prior to calculation of the filing fee in the above-captioned matter, please enter
the following amendments to the claims:

4) (AMENDED) A composition according claim 2 wherein said ester is an ethyl,
propyl, or butyl ester of said acid.

5) (AMENDED) A composition according to claim 2 wherein the ratio of said acid to
said ester is from 0.01 to 10.

6) (AMENDED) A composition according to claim 1 wherein said auxiliary stabiliser is
present in a amount of from 0.05 to 5% by weight of the composition.

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7) (AMENDED) A composition according to claim 1 which additionally contains from 0.01 to 10% by weight of the composition of a clay.

Please add the following new claims:

10) (NEW) A composition according to claim 3 wherein said ester is an ethyl, propyl, or butyl ester of said acid.

11) (NEW) A composition according to claim 3 wherein the ratio of said acid to said ester is from 0.01 to 10.

12) (NEW) A composition according to claim 4 wherein the ratio of said acid to said ester is from 0.01 to 10.

13) (NEW) A composition according to claim 2 wherein said auxiliary stabiliser is present in an amount of from 0.05 to 5% by weight of the composition.

14) (NEW) A composition according to claim 3 wherein said auxiliary stabiliser is present in an amount of from 0.05 to 5% by weight of the composition.

15) (NEW) A composition according to claim 4 wherein said auxiliary stabiliser is present in an amount of from 0.05 to 5% by weight of the composition.

16) (NEW) A composition according to claim 5 wherein said auxiliary stabiliser is present in an amount of from 0.05 to 5% by weight of the composition.

17) (NEW) A composition according to claim 2 which additionally contains from 0.01% to 10% by weight of the composition of a clay.

18) (NEW) A composition according to claim 3 which additionally contains from 0.01% to 10% by weight of the composition of a clay.

19) (NEW) A composition according to claim 4 which additionally contains from 0.01% to 10% by weight of the composition of a clay.

20) (NEW) A composition according to claim 5 which additionally contains from 0.01% to 10% by weight of the composition of a clay.

Claims 4, 5, 6, and 7 have been amended herein, and new claims 10- 20 added.

Support for the added new claims may be found in the multiple-dependent claims originally filed in this case. Attached hereto is a marked-up version of the changes

made to the claims by the current amendment. The attached page is captioned:

"Version with markings to show changes made".

Respectfully Submitted,

A handwritten signature in black ink, appearing to read "Chris Whewell". The signature is fluid and cursive, with the first name "Chris" and last name "Whewell" clearly distinguishable.

Christopher J. Whewell, Reg. No. 37,469
c/o Huntsman Corp.
7114 North Lamar Boulevard
Austin, Tex. 78752
(512) 483-0919

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Version with markings to show changes made

4) (AMENDED) A composition according to ~~either of claims 2 and 3~~ claim 2 wherein said ester is an ethyl, propyl, or butyl ester of said acid.

5) (AMENDED) A composition according to ~~any of claims 2 to 4~~ claim 2 wherein the ratio of said acid to said ester is from 0.01 to 10.

6) (AMENDED) A composition according to ~~any foregoing claim~~ claim 1 wherein said auxiliary stabiliser is present in a amount of from 0.05 to 5% by weight of the composition.

7) (AMENDED) A composition according to ~~any foregoing claim~~ claim 1 which additionally contains from 0.01 to 10% by weight of the composition of a clay

STRUCTURED SURFACTANT SYSTEMS

The present invention relates to the formulation of structured surfactant suspending systems. It is particularly relevant to the formulation of laundry detergents especially those used for industrial and institutional cleaning.

STRUCTURED SURFACTANT

Suspending solids in liquids presents a problem. If the solids differ in density from the liquid they will tend either to sediment or float. Increasing the viscosity of the liquid can retard, but not prevent such separation, and high viscosities are generally undesirable. Colloidal systems, in which the suspended particles are sufficiently small to experience Brownian motion, e.g. less than 1 micron, may be kinetically stable. However the difficulty or undesirability of comminuting some solids to such sizes, and the impossibility of maintaining many of them at this level in the face of crystal growth or agglomeration, limits the use of colloidal suspensions.

Adjusting the density of one phase to match that of the other is usually impracticable. Moreover such systems are almost always temperature-unstable due to differential rates of thermal expansion.

One method of suspension which permits even relatively large particles to be stably suspended is structured surfactant. The term covers systems in which a surfactant mesophase, usually a lamellar or G-phase, alone or more usually interspersed with an aqueous phase, provides a yield stress which is sufficient, when the system is at rest, to immobilise any suspended particles, but which is sufficiently low to allow the system to be poured like a normal liquid. Such systems may display very low apparent viscosities when stirred, pumped or poured and yet be capable of maintaining particles, sometimes of millimetre or larger size, indefinitely in suspension.

Three main types of suspending system have been employed in practice, all involving a G-phase, in which bilayers of surfactant are arranged with the hydrophobic part of the molecule on the interior and the hydrophilic part on the exterior of the bilayer (or vice versa). The bilayers lie side by side, e.g. in a parallel or concentric configuration, sometimes separated by aqueous layers. G-phases (also known as L_{α} phases) can usually be identified by their characteristic textures under the polarising microscope and/or by x-ray diffraction, which is often able to detect evidence of lamellar symmetry. Such evidence may comprise first, second and sometimes third order peaks with d-spacing ($\frac{2\pi}{Q}$ where Q is the momentum transfer vector) in a simple integral ratio 1:2:3. Other types of symmetry give different ratios, usually non integral.

Most surfactants form a G-phase either at ambient or at some higher temperature when mixed with water in certain specific proportions. However such G-phases cannot usually be used as structured suspending systems. Useful quantities of solid render them unpourable and smaller amounts tend to sediment.

The main types of structured system used in practice are based on dispersed lamellar, spherulitic and attenuated lamellar phases. Dispersed lamellar phases are two phase systems in which the surfactant bilayers are arranged as parallel plates to form domains of G-phases which are interspersed with an aqueous phase to form an opaque gel-like system. They are described in EP O 086 614.

Spherulitic phases comprise well defined spheroidal bodies, usually referred to in the art as spherulites, in which surfactant bilayers are arranged as concentric shells. The spherulites usually have a diameter in the range 0.1 to 15 microns and are dispersed in an aqueous phase in the manner of a classical emulsion, but interacting to form a structured system. Spherulitic systems are described in more detail in EP O 151 884.

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Many structured surfactant systems are intermediate between dispersed lamellar and spherulitic, involving both types of structure. Usually systems having a more Spherulitic character are preferred because they tend to have lower viscosity. A variant on the spherulitic system comprises prolate or rod shaped bodies sometimes referred to as batonets.

A third type of structured surfactant system comprises an expanded G-phase. It differs from the other two types of structure system in being essentially a single phase, and from conventional G-phase in having a wider d-spacing. Conventional G-phases have a d-spacing of about 5 to 7 nanometers. Attempts to suspend solids in such phases results in stiff pastes which are either non-pourable, unstable or both. Expanded G-phases with d-spacing between 8 and 20, e.g. 10 to 15 nanometers, form when the electrolyte is added to aqueous surfactants at concentrations just below those required to form a normal G-phase, particularly to surfactants in the M phase. The M phase comprises surfactant molecules arranged to form cylindrical rods of indefinite length. It exhibits hexagonal symmetry and a distinctive texture under the polarising microscope. Typical M phases have so high a viscosity that they appear to be curdy solids. M phases near the lower concentration limit (the L_1 /M phase boundary) may be pourable but have a very high viscosity and often a mucous-like appearance. Such systems tend to form expanded G-phases particularly readily on addition of sufficient electrolyte.

Expanded G-phases are described in more detail in EP O 530 708. In the absence of suspended matter they are translucent, unlike dispersed lamellar or spherulitic phases which are necessarily opaque. They are optically anisotropic and have shear dependent viscosity. In this they differ from L_1 phases which are micellar solutions and which include microemulsions. L_1 phases are clear, optically isotropic and substantially Newtonian. They are unstructured and cannot suspend solids. Some L_1 phases exhibit small angle x-ray diffraction spectra which show evidence of hexagonal symmetry. Such phases usually have concentrations near the L_1 /M phase boundary and may form expanded G-phases on addition of electrolyte.

Most structured surfactant systems require the presence of electrolyte as well as surfactant and water in order to form structured systems capable of suspending solids. However certain relatively hydrophobic surfactants such as isopropylamine alkyl benzene sulphonate can form spherulites in water in the absence of electrolyte. Such surfactants are capable of suspending solids in the absence of electrolyte as described in EP O 414 549.

THE PROBLEM

A problem with the two phase structured surfactant systems, and especially spherulitic systems, is flocculation of the dispersed surfactant structures. This tends to occur at high surfactant and/or high electrolyte concentration. It can have the effect of making the composition very viscous and/or unstable with the dispersed surfactant separating from the aqueous phase.

THE PRIOR ART

Certain amphiphilic polymers have been found to act as deflocculants of structured surfactants. One type of deflocculant polymer exhibits cteniform (comb-shaped) architecture with a hydrophilic backbone and hydrophobic side chains or vice versa. A typical example is a random copolymer of acrylic acid and a fatty alkyl acrylate. Cteniform deflocculants have been described in a large number of patents, for example WO-A-9106622.

A more effective type of deflocculant has surfactant rather than cteniform architecture. With a hydrophilic polymer group attached at one end to a hydrophobic group. Such deflocculants are typically telomers formed by telomerising a hydrophilic monomer with a hydrophobic telogen. Examples of surfactant deflocculants include alkyl thiol polyacrylates and alkyl polyglycosides. Surfactant deflocculants are described in more details in EP O 623 670.

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A disadvantage of both surfactant and cteniform deflocculants is that the concentration required to deflocculate to the extent required for optimum viscosity is critical within fairly narrow limits and varies with temperature. Either too much or too little deflocculant causes instability and/or excessive viscosity. As a result the deflocculated systems tend to separate or congeal if the temperature varies significantly. In particular, separation of a clear bottom layer is often observed on storage.

One approach to the problem of temperature stability has been to add highly cross linked polyacrylates (see US 5 602 092). These, however, are difficult to disperse in the structured liquid.

Structured surfactants have been applied to the problems of suspending: water insoluble or sparingly soluble builders in laundry detergent; antifoams and enzymes in laundry detergents and other surfactant systems; abrasives in hard surface cleaners; pesticides and oils in agrochemical preparations; rock cuttings in drilling muds; dyestuffs in dye bath concentrates and printing inks; talcs, oils and other cosmetic ingredients in personal care formulations.

THE SOLUTION

We have now discovered that a substantially non-cross linked polymer having a hydrophilic backbone and sufficient short (e.g. $C_{1 \text{ to } 5}$) side chains to enhance physical entanglement of the polymer molecules has the ability to stabilise deflocculated structured surfactant systems, but is more soluble and easier to disperse than the cross linked polymers used hitherto.

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THE INVENTION

Our invention provides a structured surfactant composition capable of suspending solids which comprises surfactant water and, if required, electrolyte in relative proportions adapted to form a flocculated, dispersed lamellar and/or spherulitic structured surfactant system, and, in addition, sufficient of a deflocculant to inhibit the flocculation of said system characterised in that said composition comprises an effective amount of an auxiliary stabiliser which is a substantially non-cross linked, water-soluble copolymer having a hydrophilic backbone and sufficient C₂₋₆ hydrophobic organic side chains to permit entanglement of the polymer chain. For convenience as used herein "side chain" includes cyclic side chains such as a benzene, cyclohexane or cyclopentane ring, attached to the hydrophilic backbone.

THE AUXILIARY STABILISER

The auxiliary stabiliser may be a copolymer of (a) one or more unsaturated carboxylic or dicarboxylic acids having from 3 to 6 carbon atoms and/or vinyl alcohol with (b) styrene and/or a C_{1 to 5} alkyl ester of a C_{3 to 6} unsaturated carboxylic or dicarboxylic acid and/or a vinyl alcohol ester of a C_{2 to 6} carboxylic acid wherein the mole ratio of (a):(b) is from 0.01 to 10, preferably more than 0.1, especially more than 0.2, e.g. more than 0.5, but preferably less than 8, especially less than 5, e.g. less than 2. The polymer is substantially non-cross linked by which is meant that it comprises less than 0.05% cross linking and/or insufficient cross linking to provide pseudo plastic behaviour. Preferably the auxiliary stabiliser gives the formulation a Sisko Index of 0.1 to 0.4, e.g. 0.2 to 3.

The polymer is preferably present in an amount of from 0.01 to 10% by weight of the composition e.g. 0.05 to 5%, especially 0.1 to 2%, e.g. 0.5 to 1.5% by weight.

The polymer may preferably be a copolymer of acrylic acid with for example ethyl, propyl or butyl acrylate and/or styrene. Alternatively, a copolymer comprising vinyl alcohol and vinyl acetate propionate or butyrate residues could be used. Other

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monomers include maleic acid, fumaric acid, citraconic acid, aconitic acid, itaconic acid, crotonic acid, isocrotonic acid, angelic acid and tiglic acid and their esters or partial esters. The effectiveness of the auxiliary stabiliser may be enhanced by the presence of a clay such as bentonite. The latter, however, is not normally sufficient to stabilise the composition in the absence of the polymer. Particularly preferred are water dispersible synthetic layered silicates such as that sold by Laporte under its Registered Trade Mark "LAPONITE".

It has been found that clays and, in particular, synthetic layered silicates are synergistic with the copolymeric auxiliary stabilisers. This provides a further aspect of the invention. The clay is generally used in amounts between 0.01 and 10% by weight of the composition. Typically using clays such as bentonite, proportions of from 0.1 to 8% may be used, more usually 0.5 to 5%, e.g. 1 to 3%. However, synthetic layered silicates are effective in substantially lower concentrations e.g. 0.01 to 2%, e.g. 0.05 to 1%, especially 0.1 to 0.5% by weight. Use of the clay or silicate permits the proportion of copolymer to be substantially reduced, e.g. 0.01 to 0.5% by weight based on the weight of the composition.

The invention therefore provides, according to a further embodiment an auxiliary stabiliser for deflocculated structured surfactants which comprises from 10 to 90% by weight of a copolymer having a hydrophilic backbone and $C_{2 \text{ to } 6}$ hydrophobic side chains, with from 90 to 10% by weight of a natural or synthetic clay.

DEFLOCCULANT

The deflocculant may be a surfactant deflocculant including any of those referred to in EP O 623 670. Particularly preferred are the alkyl thiol polycarboxylate telomers such as a C_{8-20} alkyl thiol polyacrylate or polymaleate and alkyl polyglycosides such as C_{8-20} alkyl polyglucoside e.g. having a D.P. greater than 1.2, preferably greater than 1.5. Alternatively the stabiliser may be a cteniform polymer of the type described in WO-A-9106622. The deflocculant is typically present in the amount required to deflocculate the system. This depends on the nature of the surfactant and of the

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deflocculant but is typically in the range 1 to 5% although higher concentrations may be required in some cases.

SURFACTANT

Compositions according to the present invention generally contain at least sufficient surfactant to form a structured system. For some surfactants this may be as low as 2% by weight, but more usually requires at least 3%, especially at least 4%, typically more than 5% by weight of surfactant.

Detergent compositions of the present invention preferably contain at least 10% by weight of total surfactant (including the deflocculant, where the latter is a surfactant) based on the total weight of the composition. Most preferably the total surfactant is at least 20%, especially more than 25%, e.g. more than 30% by weight of the composition. It is unlikely in practice that the surfactant concentration will exceed 80% based on the weight of the composition and is usually less than 70% especially less than 60%, typically less than 50% e.g. less than 40% by weight of the composition.

The amount of surfactant present in the composition is preferably greater than the minimum which is able, in the presence of a sufficient quantity of surfactant-desolubilising electrolyte, to form a stable, solids-suspending structured surfactant system.

The surfactant may comprise anionic, cationic, non-ionic, amphoteric semi polar and/or zwitterionic species or mixtures thereof.

Anionic surfactant may comprise a C₁₀₋₂₀ alkyl benzene sulphonate or an alkyl ether sulphate which is preferably the product obtained by ethoxylating a natural fatty or synthetic C₁₀₋₂₀ e.g. a C₁₂₋₁₄ alcohol with from 1 to 20, preferably 2 to 10 e.g. 3 to 4 ethyleneoxy groups. optionally stripping any unreacted alcohol, reacting the ethoxylated product with a sulphating agent and neutralising the resulting alkyl ether

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sulphuric acid with a base. The term also includes alkyl glyceryl sulphates, and random or block copolymerised alkyl ethoxy/propoxy sulphates.

The anionic surfactant may also comprise, for example, C₁₀₋₂₀ e.g. C₁₂₋₁₈ alkyl sulphate.

The surfactant may comprise a C₈₋₂₀ e.g. C₁₀₋₁₈ aliphatic soap. The soap may be saturated or unsaturated, straight or branched chain.

Preferred examples include dodecanoates, myristates, stearates, oleates, linoleates, linolenates and palmitates and coconut and tallow soaps. Where foam control is a significant factor we particularly prefer to include soaps e.g. ethanolamine soaps and especially monoethanolamine soaps, which have been found to give particularly good cold storage and laundering properties.

The surfactant may include other anionic surfactants, such as olefin sulphonates, paraffin sulphonates, taurides, isethionates, ether sulphonates, ether carboxylates, aliphatic ester sulphonates, e.g. alkyl glyceryl sulphonates, sulphosuccinates or sulphosuccinamates. Preferably the other anionic surfactants are present in total proportion of less than 45% by weight, based on the total weight of surfactants, more preferably less than 40%, most preferably less than 30%, e.g. less than 20%.

The cation of any anionic surfactant is typically sodium but may alternatively be potassium, lithium, calcium, magnesium, ammonium, or an alkylammonium having up to 6 aliphatic carbon atoms including isopropylammonium, monoethanolammonium, diethanolammonium, and triethanolammonium. Mixtures of the above cations may be used.

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The surfactant preferably contains one, or preferably more, non-ionic surfactant. These preferably comprise alkoxylated C₈₋₂₀ preferably C₁₂₋₁₈ alcohols. The alkoxylates may be ethoxylates, propoxylates or mixed ethoxylated/propoxylated alcohols. Particularly preferred are ethoxylates with 2 to 20 especially 2.5 to 15 ethyleneoxy groups.

The alcohol may be fatty alcohol or synthetic e.g. branched chain alcohol. Preferably the non-ionic component has an HLB of from 6 to 16.5, especially from 7 to 16, e.g. 8 to 15.5. We particularly prefer mixtures of two or more non-ionic surfactants having a weighted mean HLB in accordance with the above values.

Other ethoxylates and/or propoxylated non-ionic surfactants which may be present include C₆₋₁₆ alkylphenol alkoxylates, alkoxylated fatty acids, alkoxylated amines, alkoxylated alkanolamides and alkoxylated alkyl sorbitan and/or glyceryl esters.

Other non-ionic surfactants which may be present include amine oxides, fatty alkanolamides such as coconut monoethanolamide, and coconut diethanolamide and alkylaminoethyl fructosides and glucosides.

The proportion by weight of non-ionic surfactant is preferably at least 2% and usually more than 10%, more typically more than 20%, e.g. 30 to 75%, especially 40 to 60% based on the total weight of surfactant. However compositions wherein the non-ionic surfactant is from 75 to 100% of the total weight of the surfactant are included and may be preferred for some applications.

The surfactant may be, or may comprise major or minor amounts of, amphoteric and/or cationic surfactants, for example betaines, sulphobetaines, amidobetaines, imidazolines, amidoamines, quaternary ammonium surfactants and cationic fabric conditioners having two long chain alkyl groups, such as tallow groups. Examples of fabric conditioners which may be deflocculated according to our invention include ditallowyl dimethyl ammonium salts, ditallowyl methyl benzyl ammonium salts, ditallowyl imidazolines, ditallowyl amidoamines and quaternised ditallowyl

imidazolines and amidoamines. The anion of the fabric conditioner may for instance be or may comprise methosulphate, chloride, sulphate, acetate, lactate, tartrate, citrate or formate. We prefer that the compositions of our invention do not contain substantial amounts of both anionic and cationic surfactants.

We particularly prefer that the surfactant consists essentially of a mixture of a non-ionic ethoxylate with an amine oxide or, preferably an amphoteric surfactant. Such mixtures exhibit strong synergistic soil removal. The mixture may desirably contain from 1:10 to 10:1 weight ratio of non-ionic to amphoteric e.g. 1:5 to 5:1.

SUSPENDED SOLIDS

A major advantage of the preferred compositions of the invention is their ability to suspend solid particles to provide non-sedimenting pourable suspension. Optionally the composition may contain up to, for example, 80% by weight, based on the weight of the composition, of suspended solids, more usually up to 30 e.g. 10 to 25%. The amount will depend on the nature and intended use of the composition. For example in detergent compositions it is often desired to include insoluble builder such as zeolite or sparingly soluble builders such as sodium tripolyphosphate which may be suspended in the structured surfactant medium.

The surfactant systems according to our invention may also be used to suspend abrasives such as talc, silica, calcite or coarse zeolite to give hard surface cleaners; or pesticides, to provide water dispersible, pourable compositions containing water insoluble pesticides, without the hazards of toxic dust or environmentally harmful solvents. They are useful in providing suspensions of pigments, dyes, pharmaceuticals, biocides, or as drilling muds, containing suspended shale and/or weighting agents such as sodium chloride, calcite, barite, galena or haematite.

They may be used to suspend exfoliants including talc, clays, polymer beads, sawdust, silica, seeds, ground nutshells or dicalcium phosphate, pearlisers such as mica, glycerol mono- or di-stearate or ethylene glycol mono- or di-stearate, natural oils,

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BUILDERS

pH

The pH of a composition for laundry use is preferably alkaline, as measure after dilution with water to give a solution containing 1% by weight of the composition, e.g. 7 to 12, more preferably 8 to 12, most preferably 9 to 11.

HYDROTROPES

Compositions of our invention may optionally contain small amounts of hydrotropes such as sodium xylene sulphonate, sodium toluene sulphonate or sodium cumene sulphonate, e.g. in concentrations up to 5% by weight based on the total weight of the composition, preferably not more than 2%, e.g. 0.1 to 1%. Hydrotropes tend to break surfactant structure and it is therefore important not to use excessive amounts. They are primarily useful for lowering the viscosity of the formulation, but too much may render the formulation unstable.

SOLVENTS

The compositions may contain solvents, in addition to water. However, like hydrotropes, solvents tend to break surfactant structure. Moreover, again like hydrotropes, they add to the cost of the formulation without substantially improving the washing performance. They are moreover undesirable on environmental grounds and the invention is of particular value in providing solvent-free compositions. We therefore prefer that they contain less than 6%, more preferably less than 5%, most preferably less than 3%, especially less than 2%, more especially less than 1%, e.g. less than 0.5% by weight of solvents such as water miscible alcohols or glycols, based on the total weight of the composition. We prefer that the composition should essentially be solvent-free, although small amounts of glycerol and propylene glycol are sometimes desired. Concentrations of up to about 3% by weight, e.g. 1 to 2% by weight of ethanol are sometimes required to enhance perfume. Such concentrations can often be tolerated without destabilising the system.

POLYMERS

Compositions of our invention may contain various polymers. In particular it is possible to incorporate useful amounts of polyelectrolytes such as uncapped polyacrylates or polymaleates. Such polymers may be useful because they tend to lower viscosity and because they have a detergent building effect and may have

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anticorrosive or antiscaling activity. Unfortunately they also tend to break surfactant structure and cannot normally be included in structured surfactants in significant amounts without destabilising the system. We have discovered that relatively high levels of polyelectrolytes can be added to structured detergents in conjunction with deflocculated polymers and auxiliary stabilisers of the invention without destabilising the structure. This can provide stable products of even lower viscosity than can be achieved with the deflocculant and auxiliary stabiliser alone.

Some examples of polymers which may be included in the formulation are antiredeposition agents such as sodium carboxymethyl cellulose, antifoams such as silicone antifoams, enzyme stabilisers such as polyvinyl alcohols and polyvinyl pyrrolidone, dispersants such as lignin sulphonates and encapsulents such as gums and resins. We have found that milling aids such as sodium dimethylnaphthalene sulphonate/formaldehyde condensates are useful where the solid suspended in the composition requires milling as in the case of dye or pesticide formulations.

The amount of polymer added depends on the purpose for which it is used. In some cases it may be as little as 0.01% by weight, or even lower. More usually it is in the range of 0.1 to 10%, especially 0.2 to 5%, e.g. 0.5 to 2% by weight.

OTHER DETERGENT ADDITIVES

The solid suspending detergent compositions of our invention may comprise conventional detergent additives such as antiredeposition agents (typically sodium carboxymethyl cellulose), optical brighteners, sequestrants, antifoams, enzymes, enzyme stabilisers, preservatives, dyes, pigments, perfumes, fabric conditions, e.g. cationic fabric softeners or bentonite, opacifiers, bleach activators and/or chemically compatible bleaches. We have found that peroxygen bleaches such as sodium perborate, especially bleaches that have been protect e.g. by encapsulation, are more stable to decomposition in formulations according to our invention than in conventional liquid detergents. Generally all conventional detergent additives which are dispersible in the detergent composition as solid particles or liquid droplets, in

excess of their solubility in the detergent, and which are not chemically reactive therewith may be suspended in the composition.

APPLICATIONS

In addition to providing novel laundry detergents, fabric conditioners and scouring creams the stabilised structured surfactants of our invention may be used in toiletries, including shampoos, liquid soaps, creams, lotions, balms, ointments, antiseptics, dentifrices and styptics.

They provide valuable suspending media for dye and pigment concentrates and printing inks, pesticide concentrates and drilling muds. In the presence of dense dissolved electrolytes such as calcium bromide they are particularly useful for oilfield packing fluids (used to fill the gap between the pipe and the inside of the borehole, to protect the former from mechanical stresses) and completion fluids in oil well, or as cutting fluids or lubricants.

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The invention will be illustrated by the following examples.

EXAMPLE 1

		%a.i.
"ACUSOL" [®] 842	non cross-linked acrylic acid/ethylacrylate copolymer	0.21
NaOH	50% soluton	0.12
"LAUNDROSIL" [®] DGA	bentonite clay	1.67
"EMPIGEN" [®] BB	C ₁₂₋₁₄ alkyl betaine	2.25
"BEVALOID" [®] XB16/01H	C ₁₆ alkylthiolpolyacrylate	0.10
"EMPILAN" [®] KBE3	C ₁₂₋₁₄ alkyl 3 mole ethoxylate	4.42
"WACKER" [®] S131	silicone antifoam	0.13
"BRIQUEST" [®] 543/25S	phosphonate	0.42
"TINOPAL" [®] CBS/X	optical brightener	0.06
	sodium carboxymethyl cellulose	0.08
	calcium chloride	0.21
"ALCALASE" [®] DX	protease enzyme	0.08
"TERMAMYL" [®] 300L	amylase enzyme	0.08
"PROXEL" [®]	preservative	0.02
	boric acid	0.83
Non-bio 32	perfume	0.33
STP/1L	sodium tripolyphosphate	20.8
	water	Balance

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The above formulation was mobile and stable after three months storage. In the absence of the "ACUSOL" copolymer the composition underwent slow separation of a clear bottom layer over several weeks. This separation could not be prevented by increasing the amount of bentonite, even up to double the amount. In the absence of the bentonite some separation occurred which could be prevented by increasing the amount of "ACUSOL" copolymer.

EXAMPLE 2

		%a.i.
"LAPONITE" [®] RD	syntethic layer silicate clay	0.2
"ACUSOL" [®] 842	non cross linked acrylic acid/ethyl acrylate copolymer	0.3
NaOH	sodium hydroxide	0.17
"EMPIGEN" [®] BB	C ₁₂₋₁₄ alkyl betaine	2.75
"BEVALOID" [®] XB16/01H	alkylthiol polyacrylate	0.16
"EMPILAN" [®] KBE3	C ₁₂₋₁₄ alcohol 3EO ethoxylate	4.95
"WACKER" [®] S131	silicone antifoam	0.25
	sodium tripolyphosphate	21.9
"BRIQUEST" [®] 543/25S	amino phosphonate	0.27
"REPELOTEX" [®] QCJ	soil release polymer	0.3
	water	Balance
Viscosity 1000cps (Brookfield Spindle4 100 rpm)		

The composition was stable on storage. Without the "ACUSOL" copolymer and "LAPONITE" synthetic clay the composition underwent rapid sedimentation. In the absence of the "ACUSOL" copolymer the composition could only be stabilised by the use of uneconomically high proportions of the clay.

In the absence of the clay, substantially higher concentrations of the "ACUSOL" copolymer were required which were significantly less cost effective than the mixture.

CLAIMS

1. A structured surfactant composition capable of suspending solids which comprises surfactant, water and, if required, electrolyte in relative proportions adapted to form a flocculated, dispersed lamellar and/or spherulitic structured surfactant system, and, in addition, sufficient of a deflocculant to inhibit the flocculation of said system characterised in that said composition comprises an effective amount of an auxiliary stabiliser which is a substantially non-cross linked, water-soluble copolymer having a hydrophilic backbone and sufficient C₂₋₆ hydrophobic organic side chains to permit entanglement of the polymer chain.
2. A composition according to claim 1 wherein said auxiliary stabiliser is a copolymer of an unsaturated carboxylic or dicarboxylic acid having from 3 to 6 carbon atoms and a C₁ to ₅ alkyl ester of such an acid.
3. A composition according to claim 2 wherein said acid is acrylic acid.
4. A composition according to either of claims 2 and 3 wherein said ester is an ethyl, propyl or butyl ester of said acid.
5. A composition according to any of claims 2 to 4 wherein the ratio of said acid to said ester is from 0.01 to 10.
6. A composition according to any foregoing claim wherein said auxiliary stabiliser is present in a amount of from 0.05 to 5% by weight of the composition.
7. A composition according to any foregoing claim which additionally contains from 0.01 to 10% by weight of the composition of a clay.

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8. A composition according to claim 7 wherein said clay is a water dispersible synthetic layer silicate.
9. An auxiliary stabiliser for deflocculated structured surfactants which comprised from 10 to 90% by weight of a copolymer having a hydrophilic backbone and C₂ to C₆ hydrophobic side chains, with from 90 to 10% by weight of a natural or synthetic clay.

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HUNTSMAN

Power of Attorney

I, Peter R. Huntsman, hereby certify that I am an officer of Huntsman International LLC. (the "Corporation"), a corporation, duly organized, validly existing and in good standing under the laws of the State of Delaware, in the United States of America, with the authority to and hereby grant, on behalf of the Corporation:

Philippus Johannes Leonardus Henricus Baken,
Marnix Karel Christiane Moens,
Edward John Nevard,
Anne Marie Swinnen,
Kevin J. Boland,
Russell Robert Stolle,
Ron David Brown,
Nicole Peffer, and
Christopher Jon Whewell

the power to act in the name of the Corporation, and on behalf of the Corporation, to execute, acknowledge, verify, file, record and cause to be published all notices, agreements, instruments, deeds, certificates, applications, and all other documents that shall be necessary or advisable for the purpose of procuring, transferring, assigning, licensing, or discharging intellectual properties (collectively and separately including patents & patent applications, trademarks & trademark applications, copyrights and copyright applications and know-how, in particular trade secrets) of all types and in all jurisdictions (hereinafter collectively "the Purpose"); and to:

- (i) appoint attorneys or agents in any and all jurisdictions, including other persons within the Corporation, and delegate to or revoke from them the same, or any portion thereof, powers hereinbefore conferred as deemed necessary or advisable for the promotion of the Purpose;
- (ii) make, authorize, and receive payments, on its behalf, which may be deemed necessary or advisable for the promotion of the Purpose; and
- (iii) generally to sign, execute, give and accept all such papers, communications and other items as may be necessary or advisable for the promotion of the Purpose.

IN WITNESS WHEREOF, the Corporation have executed this Certificate and Power to be effective as of January 1st, 2001.

Huntsman International LLC.

By 

Date

01 JAN. 2001

DECLARATION FOR PATENT APPLICATION

As an undersigned inventor, I hereby declare that:

My residence, post office address and country of citizenship are as stated directly below my name.

I believe (check one) ☒ I am the original, first and sole inventor
☐ I am a joint inventor and the below named inventors are the original and first inventors

of the subject matter which is claimed and for which a patent is sought on the invention entitled "**STRUCTURED SURFACTANT SYSTEMS**" (Attorney Docket **MPD314**), the specification of which

(check one) ☐ is attached hereto.

☒ was filed on June 22, 2000

as Application Serial No. PCT/GB00/02448

and was amended on _____
(if applicable)

I further declare that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose to the United States Patent and Trademark Office (hereinafter "the Office") all information known to me to be material to patentability of the subject matter which is claimed as defined in 37 C.F.R. §1.56.

I hereby claim foreign priority benefits under 35 U.S.C. §119 of any foreign application(s) for patent or inventor's certificate indicated below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

Prior Foreign Application(s)			Priority Claimed	
Number	Country	Day/Month/Year Filed	Yes	No
<u>9914671.4</u>	<u>Great Britain</u>	<u>24 June 1999</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
_____	_____	_____	<input type="checkbox"/>	<input type="checkbox"/>

I hereby claim the benefit under 35 U.S.C. §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of 35 U.S.C. §112, I acknowledge the duty to disclose to the Office all information known to me to be material to patentability as defined in 37 C.F.R. §1.56, which became available between the filing date of the prior application and the national or PCT international filing date of this application:


Application Serial No.	Filing Date	Status (patented, pending, abandoned)
_____	_____	_____
_____	_____	_____

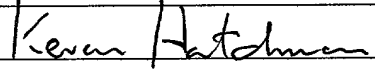
Address all telephone calls to Christopher J. Whewell at telephone number 512 483 0919.

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further, that these statements were made with the knowledge that willful false statements and the like are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and may jeopardize the validity of the application or any patent issued thereon.

Full name of first joint inventor  Kevan Hatchman

Inventor's Signature  5-2-2002
Date

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Citizenship British CoBX

Post Office Address Same

Full name of second inventor, if any _____

Inventor's Signature _____ Date _____

Residence _____

Citizenship _____

Post Office Address _____